

Work Order ID 63333-1

Wednesday, October 27, 2010 3:51:14 PM



Page 1

Item ID: D3910-3

Revision ID:

Item Name: Crosstube Lug

Start Date: 10/27/2010 Start Qty: 400

Required Date: 11/11/2010 Req'd Qty: 400

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10/28 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3910

B

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut to 1.450" Long

cut @ Metec

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV:

DWG REV:

DEBURR

Issue P.O to Metec P/O 13000
Machine per drawing D3910 Rev B.

CL 10/11/24 30



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 63333

Wednesday, October 27, 2010 3:51:14 PM



Page 3

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 10/27/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

*M 115981 START 11:00
OUT 5:00
FINISH 11:30*

Memo

0.00

20 BL 10-11-09

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

=) H 10/11/29

Memo

0.00

20 0

170



Packaging

Packaging

Identify as per dwg & Stock Location: *507*

0.00

Memo

0.00

10/11/09 20 SV

POSITIVE RECALL

EFFECTIVE 10.11.29 AUTH *el*

RELEASED 10.11.29 DATE *el*

W/O:		WORK ORDER CHANGES					
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Work Order ID 63333

Wednesday, October 27, 2010 3:51:14 PM



Page 4

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 10/27/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-11-29

CL10/11/29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 3:51:18 PM

Page 1

Work Order ID: 63333



Parent Item: D3910-3



Parent Item Name: Crosstube Lug

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423



Lug Extrusion

Manufactured

No

100

f

316.4039

0.13

0.547368

3.9

C21011125

Location

MAT06

43722

45800

Loc Qty

316.4039265

180

136.403926

Loc Code

3.9

D3910-3P

x 30

Pup/25 (20)

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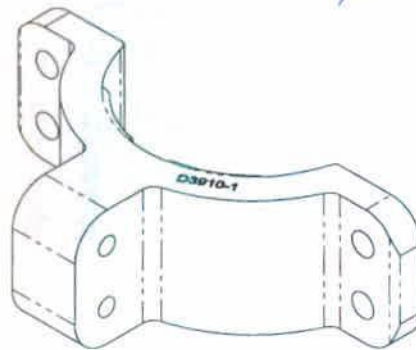
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

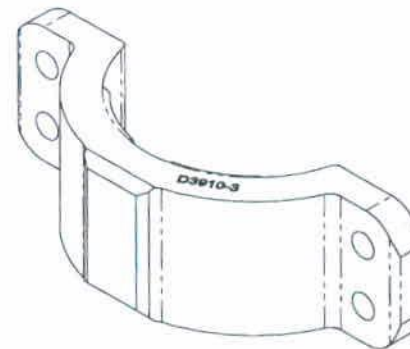
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 63333
2810-10-28



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

RELEASED
 2010-03-22
 MP

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-807-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED			DRAWING NO.	REV. B
MFG. APPR.			D3910	SHEET 1 OF 3
APPROVED			TITLE	SCALE
DE APPR.			X-TUBE LUG (350)	NTS
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

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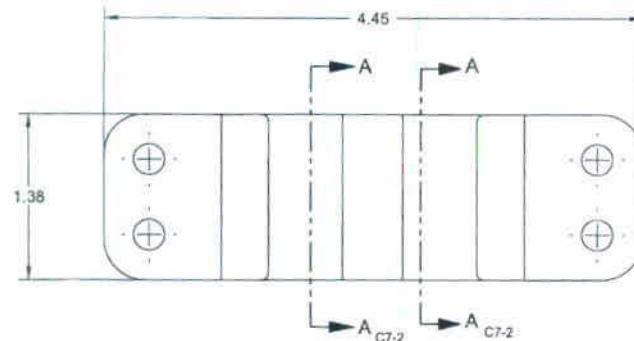
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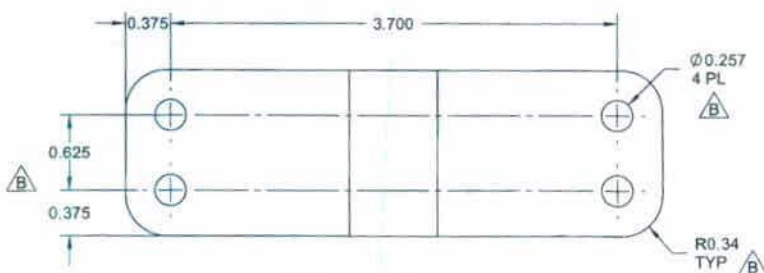
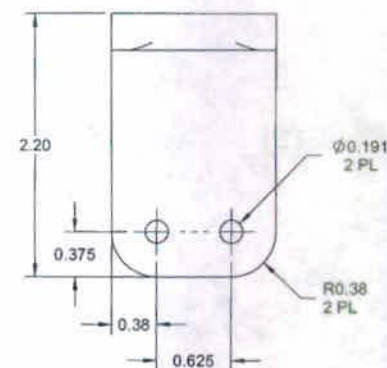
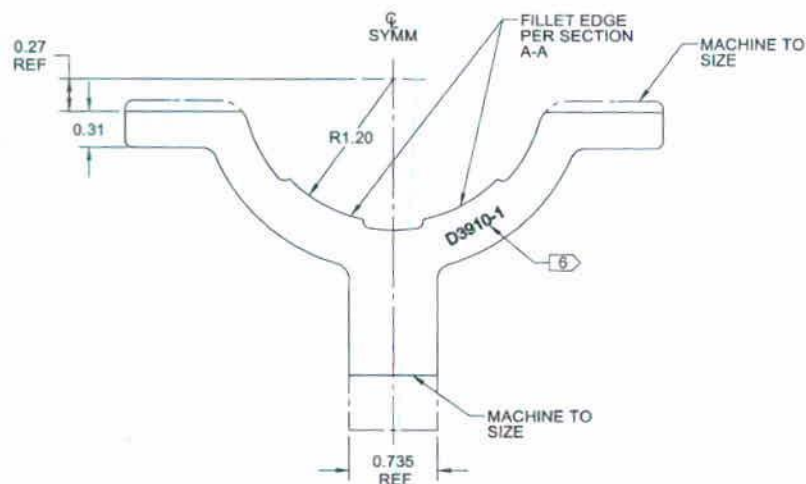


ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2



WLO 63333



D3910-1 X-TUBE LUG

RELEASED
2010-03-22

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3910	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		X-TUBE LUG (350)	SCALE
DE APPR.			NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13000

Purchase Order Date 11/24/10
PO Print Date 11/24/10

Page Number 1 of 2

Order From : VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name
Vendor Phone 613 678 3957
Vendor Fax 613 678 3956
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
C 10/11/24

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3910-3P	Crosstube Lug	11/29/10 Yes	30.00 Each		\$31.5500	\$946.50
		Special Inst:	MACHINE AS PER DWG D3910 REV. B B63333 REQUIRED ASAP PLEASE RUSH ORDER				
2	D3910-1P	CROSSTUBE LUG	12/01/10 Yes	20.00 Each		\$31.5500	\$631.00
		Special Inst:	MACHINE AS PER DWG D3910 REV. B B64016				
3	D2230-1P	LUG	12/06/10 Yes	60.00 Each		\$18.9500	\$1,137.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B63319				
4	D2230-3P	LUG	12/08/10 Yes	60.00 Each		\$10.4000	\$624.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 11/24/10

REÇU DE LIVRAISON - DELIVERY RECEIPT

DE FROM		211910	
A TO		DATE	
ADRESSE ADDRESS		VOTRE N° DE COMMANDE YOUR ORDER NO.	
COLIS PACKAGES	VILLE CITY		POIDS WEIGHT
REÇU EN BON ÉTAT RECEIVED IN GOOD CONDITION			
1	2x Long D3910-2P		
2	1x Long D3910-2P B10		
3			
4			
5			
6			
REÇU PAR RECEIVED BY		NOMBRE DE COLIS NUMBER OF PACKAGES	POIDS TOTAL TOTAL WEIGHT
		C.R. COD	FRAIS DE LIVRAISON DELIVERY CHARGE

Blueline DCB56

REÇU DE LIVRAISON - DELIVERY RECEIPT

DE FROM METEC		211910	
A TO DART A.H. Chantal		DATE Nov. 26, 10	
ADRESSE ADDRESS		VOTRE N° DE COMMANDE YOUR ORDER NO.	
VILLE CITY			
COLIS PACKAGES	REÇU EN BON ÉTAT RECEIVED IN GOOD CONDITION	POIDS WEIGHT	
1	20 x LUGS D3910-3P		
	(10 x LUGS D3910-3P B/O)		
REÇU PAR RECEIVED BY	NOMBRE DE COLIS NUMBER OF PACKAGES	POIDS TOTAL TOTAL WEIGHT	
	C.R. COD	FRAIS DE LIVRAISON DELIVERY CHARGE	



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITYPART NUMBERPART NAMEP.O. NUMBER

20

D3910-3


Crosstube Lug

13000

MATERIAL: supplied by DART D2423 B45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

8/20/11/25

Vankleek Hill, November 26, 2010